



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

SWA10A-2
Job Sheet 179862



Part No: SWA10A-2

Job Qty: 1 ea

Part Name: Electric Swivel 10,000 lb Safe Work Load (4,536 Kg)



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/25/18

Job Tracking No:

Due Date: 8/31/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG SWA10A Rev 3 IPP Rev A 17.12.20 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		8/31/18	0.00	0.00	Start Up Small Fab-2		
110	Small Fab	1 pcs		8/31/18	0.00	2.00	Small Fab-6		
120	QC	1 pcs		8/31/18	0.00	0.00	QC5		
125	DC	1 pcs		8/31/18	0.00	0.00	DC		
130	Packaging	1 pcs		8/31/18	0.00	0.00	Packaging3		
140	QC21-FG	1 Ea		8/31/18	0.00	0.00	QC21		

Part Op 110 - Assemble as per DWG. Sheet 1 ***All assembly to be done in accordance with SWA swivel manual*** Engrave T/N
Descriptions: And / or S/N number as required Using Marktronic engraver as per DWG. Laser engrave dart logo as per DWG.

120 - Engrave T/N And / or S/N number as required Using Marktronic engraver as per DWG.

125 - Photocopy blue file OM & OOPM-SWA10A Rev2

130 - Bag and tag

LOCTITE 242 (M138766)
LOCTITE 620 (M138800)
LOCTITE SILICONE GE (M138992)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
188-FPSS-1032-5/8	Set Screw	1 Ea (1 ea)	90-Start up Operation	5037083
188-FSCS-1032-5/8	Screw	4 Ea (4 ea)	110-Small Fab	5078378
C10-28	Swivel Bushing, C10/SWA10	1 Ea (1 ea)	110-Small Fab	5095933
EL-PLUG-F	3-Prong Female Spade Plug	1 Ea (1 ea)	110-Small Fab	5072958
EL-PLUG-M	3-Prong Male Spade Plug	1 Ea (1 ea)	110-Small Fab	5097889
EL314-SJTOW	3 Wire	6 ft (6 ea)	110-Small Fab	5047767
SWA10A-100	Lower End	1 Ea (1 ea)	110-Small Fab	5085046
SWA10A-1100	Upper DU Bearing	1 Ea (1 ea)	110-Small Fab	5097839
SWA10A-1200 P	Lower DU Bearing	1 Ea (1 ea)	110-Small Fab	5029451
SWA10A-1300	Roller Thrust Bearing	1 Ea (1 ea)	110-Small Fab	5066115
SWA10A-1400	Circlip	1 Ea (1 ea)	110-Small Fab	5077643
SWA10A-1800	Cover	1 Ea (1 ea)	110-Small Fab	5099112
SWA10A-200	Upper End Swivel	1 Ea (1 ea)	110-Small Fab	5094924
SWA10A-300	Bearing Housing	1 Ea (1 ea)	110-Small Fab	5098673
SWA10A-400	Thrust Washer	1 Ea (1 ea)	110-Small Fab	5098218
SWA10A-500	Semi-Rings	1 Ea (1 ea)	110-Small Fab	5068691
SWA10A-600	Collar	1 Ea (1 ea)	110-Small Fab	5100678
SWA10A-700 A	Wire Clamp	2 Ea (2 ea)	110-Small Fab	5047590
SWA6A-1900	Female Spade Terminal - 1/4"	4 Ea (4 ea)	110-Small Fab	5047603
SWA6A-800A	Connector Bushing	1 Ea (1 ea)	110-Small Fab	5031156
SWA6A-900A	Rotary Contact	1 pcs (1 ea)	110-Small Fab	5077690

DART
AEROSPACE

1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S105318



Part: SWA10A-2

Job No: 179862

Serial No/Batch: S105318

Revision: 3

Inspector:

Exp Date:

Instructions:

Date: 08/27/18

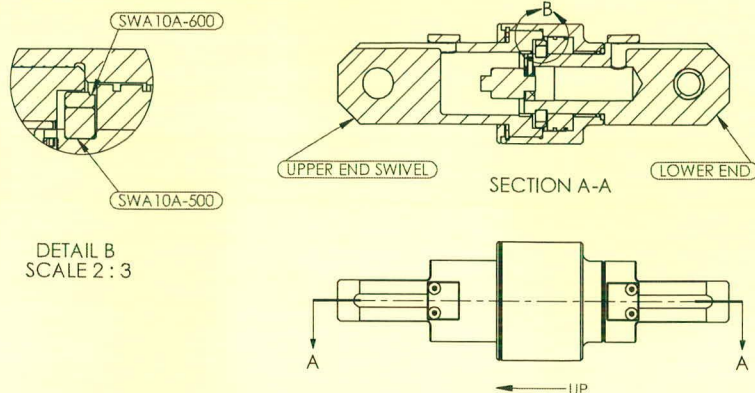
Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	188-FPSS-1032-5/8	1	369	0
110-Small Fab	188-FSCS-1032-5/8	4	465	0
	C10-28	1	26	0
	EL-PLUG-F	1	43	0
	EL-PLUG-M	1	89	0
	EL314-SJTOW	6	891	0
	SWA10A-100	1	0	0
	SWA10A-1100	1	3	0
	SWA10A-1200	1	39	0
	SWA10A-1300	1	33	0
	SWA10A-1400	1	34	0
	SWA10A-1800	1	1	0
	SWA10A-200	1	0	0
	SWA10A-300	1	3	0
	SWA10A-400	1	3	0
	SWA10A-500	1	35	0
	SWA10A-600	1	3	0
	SWA10A-700	2	52	0
	SWA6A-1900	4	228	0
	SWA6A-800A	1	24	0
	SWA6A-900A	1	16	0

Part Specifications

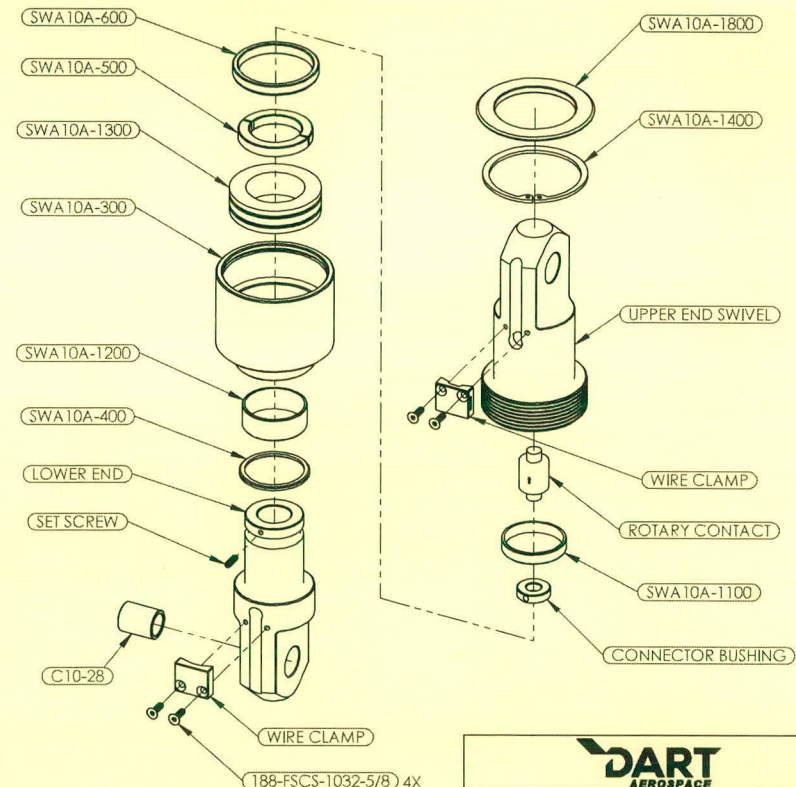
Specifications could not be found.

This drawing, specifications, and concepts contained herein are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.



-2/ QTY.	-3/ QTY.	-4/ QTY.	-6/ QTY.	-8/ QTY.	B/O	Part #	Description	Material	B/O INFORMATION OR SPECIFICATIONS
1	1	1	-	-		SWA10A-100	LOWER END	SS 17-4 H1150/H1075	
-	-	-	1	1		SWA10A-110	LOWER END	SS 17-4 H1150/H1075	
1	1	1	-	-		SWA10A-200	UPPER END SWIVEL	SS 17-4 H1150/H1075	
-	-	-	1	1		SWA10A-210	UPPER END SWIVEL	SS 17-4 H1150/H1075	
1	1	1	1	1		SWA10A-300	BEARING HOUSING	SS 17-4 H1150/H1075	
1	1	1	1	1		SWA10A-400	THRUST WASHER	AL-BRONZE 630	
1	1	1	1	1		SWA10A-500	SEMI-PIRGIS	SS 17-4 H1150/H1075	
1	1	1	1	1		SWA10A-600	COLLAR	SS 17-4 H1150/H1075	
2	2	-	-	-		SWA10A-700	WIRE CLAMP	6061-T6	
-	-	2	2	2		SWA10A-750A	WIRE CLAMP	6061-T6	
1	-	-	-	-		SWA6A-800A	CONNECTOR BUSHING		
-	1	1	-	-		SWA6A-800B	CONNECTOR BUSHING		
-	-	-	1	-		SWA6A-800C	CONNECTOR BUSHING		
1	-	-	-	-	B/O	SWA6A-900A	ROTARY CONTACT		MERCOTAC #230
-	1	-	-	-	B/O	SWA6A-900B	ROTARY CONTACT		MERCOTAC #330
-	-	1	-	-	B/O	SWA6A-900C	ROTARY CONTACT		MERCOTAC #430
-	-	-	1	-	B/O	SWA6A-900D	ROTARY CONTACT		MERCOTAC #630
-	-	-	-	1	B/O	SWA6A-900E	ROTARY CONTACT		MERCOTAC #830
1	1	1	1	1		SWA10A-1100	UPPER DU BEARING	BRONZE/ONITE TUBING	
1	1	1	1	1	B/O	SWA10A-1200	LOWER DU BEARING		(KAMAN MB502DDU)
1	1	1	1	1	B/O	SWA10A-1300	ROLLER THRUST BEARING		(KAMAN B1210TN)
1	1	1	1	1	B/O	SWA10A-1400	CIRCLIP		(KAMAN N5000 350 SFP)
1	1	1	1	1		SWA10A-1800	COVER	SS 17-4 H1150/H1075	
4	6	4	8	12	B/O	SWA6A-1900	1/4" FEMALE SPADE CONNECTOR		(MCMaster-CARR #69525K16)
-	-	4	4	4	B/O	SWA6A-2000	1/8" FEMALE SPADE CONNECTOR		(MCMaster-CARR #69525K14)
4	4	4	4	4	B/O	188-FSCS-1032-5/B	FLAT SOCKET CAP SCREW	S.S.	10-32 x 5/8 (MCMaster-CARR #92210A303)
-	-	-	-	1	B/O	188-FSS-1032-3/B	SET SCREW	S.S.	10-32 x 3/8 (MCMaster-CARR #94355A335)
-	-	-	1	-	B/O	188-FSS-1032-1/2	SET SCREW	S.S.	10-32 x 1/2 (MCMaster-CARR #94355A337)
1	1	1	-	-	B/O	188-FSS-1032-5/B	SET SCREW	S.S.	10-32 x 5/8 (MCMaster-CARR #92311A430)
1	1	1	1	1	B/O	EL-PLUG-F	FEMALE PLUG	PE High Density	(MCMaster-CARR #7216K6)
1	1	1	1	1	B/O	EL-PLUG-M	MALE PLUG	PE High Density	(MCMaster-CARR #7216K5)
1	1	-	-	-	B/O	EL314-SJTOW	3 WIRE	6 FT. (TEXCAN #EL 314-SJTOW 3/14)	
-	-	1	-	-	B/O	EL414-ARTIC	4 WIRE	6 FT. (TRUCK & AUTO SUPPLY #EL 414-ARTIC 4/14)	
-	-	-	1	-	B/O	EL616-ARTIC	6 WIRE	6 FT. (TRUCK & AUTO SUPPLY #EL 616-ARTIC)	
-	-	-	-	1	B/O	30806	8 WIRE	6 FT. (POLAR WIRE #30806)	
1	1	1	1	1	B/O	600.1319	UP DECAL		
1	1	1	1	1		C10-28	BUSHING	SAE 660 BRONZE 3/4" Ø SHAFT X 1 O.D. X 1-1/4" MOD.	(MCMaster-CARR #6381K193)

REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
A		REPLACED ID DECAL 600.1319 WITH LASER ETCH	11/16/2012	JAG	
2	15-0146	UPDATED TO NEW DRAFTING STANDARDS. ADDED ENGRAVE NOTES AND DETAILS. SWA6A-1900 CHD QTY: ASSY-4 WAS 8 IS 4. ASSY-6 WAS 12 IS 8. ASSY-8 WAS 16 IS 12. SWA6A-2000 ADDED P/N: ASSY-4 QTY 4. ASSY-6 QTY 4. ASSY-8 QTY 4. 188-FSS-1032-3/B ADDED P/N: ASSY-8 QTY 1. 188-FSS-1032-1/2 ADDED P/N: ASSY-4 QTY 1. 188-FSS-1032-5/B CHD QTY: ASSY-6 WAS 1 IS 0. ASSY-8 WAS 1 IS 0. EL314-SJTOW, EL414-ARTIC, EL616-ARTIC ADDED CHD QTY: WAS 6 IS 1. ADDED 6 FT TO B/O INFO. ADDED REBUILD ONLY NOTE	6/16/2015	DPD	JAG
3	17-0090	ADDED NOTE 3. SHEET 1. CHD P/N WAS EL616-ARTIC (TRUCK & AUTO SUPPLY) IS #30806 (POLAR WIRE). ADDED P/N C10-28.	5/31/2017	RJC	JAG



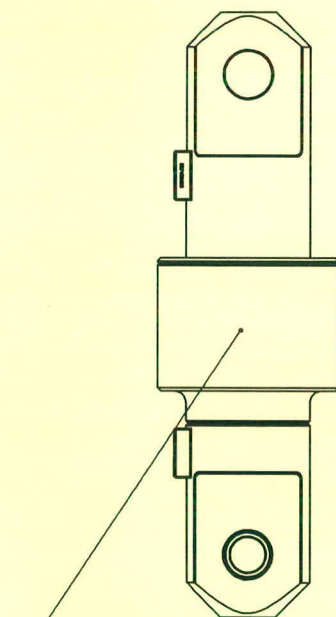
NOTES:

1. FOR REBUILD ONLY.
2. ALL ASSEMBLY TO BE DONE IN ACCORDANCE WITH SWA SWIVEL MANUAL.
3. 8 WIRE STRIP OUTER JACKET & DOUBLE LAYER HEAT SHRINK.

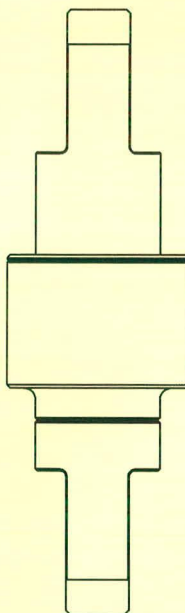
DART AEROSPACE	
TITLE SWA 10A SWIVEL	
DWG NO. SWA 10A	REV 3
MAT'L PART TREAT FINISH SPEC	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES ± 125	
1. BREAK ALL SHARP EDGES .015 x .45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: GILBERT CHECKED: DD 04/18/2017 OPS APPR: AA 05/05/2017 QA APPR: JL 05/10/2017 APPROVED: JAG 06/02/2017	
SCALE 1:4	DATE 11/14/2012
SHEET 1 OF 2	

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

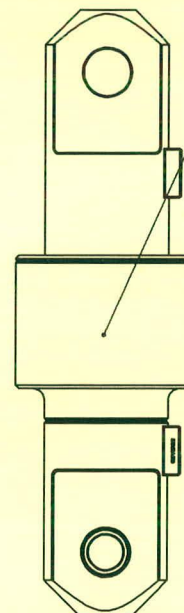
REVISIONS			
REV	ECR	DESCRIPTION	DATE
			INITIAL
			APPROVED



LASER ENGRAVE DART LOGO



ENGRAVE P/N, S/N, SWL



DART AEROSPACE	
TITLE SWA10A SWIVEL	
DWG NO. SWA10A	REV 3
MAT'L REAT TREAT FINISH SPEC	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± .5° .X ± .1 SURFACES = 125/√
DRAWN BY: GILBERT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DD 04/18/2017	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: AA 05/05/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: JL 05/10/2017	USED ON MODEL
APPROVED: JAG 06/02/2017	
SCALE 1:4	DATE 11/14/2012
SHEET 2 OF 2	

Work Order

179862

Customer

Number of Wires

2

Date

2018/08/23

Serial Number

S105318

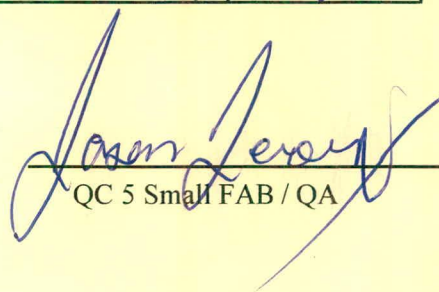
Number of Cycles	Load (Lbs.)	Action	Pass/Fail
1	10,000	Check for Conductivity against all wires.	PASS
1	10,000	Check all wires for grounding against swivel body.	PASS
1	5,000	Check for Conductivity against all wires.	PASS
1	5,000	Check all wires for grounding against swivel body.	PASS
1	2,500	Check for Conductivity against all wires.	PASS
1	2,500	Check all wires for grounding against swivel body.	PASS
1	0	Check for Conductivity against all wires.	PASS
1	0	Check all wires for grounding against swivel body.	PASS

Test Conducted By:

ALAN PATRY

Technician

Signature:


QC 5 Small FAB / QA

2200

2201

2202

2203

2204

2205

2206

2207

2208

2209

2210

2211

2212

2213

2214

2215

2216

2217

2218

2219

2220